

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004106**Date Inspected:** 02-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Makhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Deviation and Jacking Saddles**Summary of Items Observed:**

On this date OSM Quality Assurance (QA) Representative Daniel L. Reyes was present during the welding of the structural steel components regarding the West Deviation Saddles relative to this project. The following was observed:

Fabrication Shop # 4

The QA inspector traveled to the fabrication shop to observe the scheduled work on the West Deviation Saddle identified as W2E1. The work performed was the welding of temporary attachments (stay plates) located on the inside of the trough of the casting. The temporary attachments were located and welded as per the Distortion Control Plan, Document No. SJ-3109, Attachment 2. There were a total of four (4) attachments welded and were placed symmetrically in the trough of the West Deviation Saddle W2E1.

The welding was performed by Japan Steel Works (JSW) personnel Satoru Watanabe ID 08-5189 who utilized the gas shielded Flux Cored Arc Welding (FCAW-G) process during the welding of the attachments.

The QA inspector observed, at random intervals, the Intertek Inspection Service (ITS) Quality Control (QC) Inspector Makhmud Ashadi perform the visual inspection and the verification of the welding parameters and the surface temperatures.

The digital photographs on page 2 of this report illustrate the observations of the activities performed on this date.

WELDING INSPECTION REPORT

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Summary of Conversations:

There were no pertinent conversations relative to the project on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer, (858) 967-6363, who represents the Office of Structural Materials for your project.

Inspected By:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
